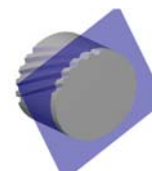
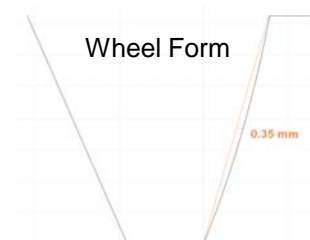
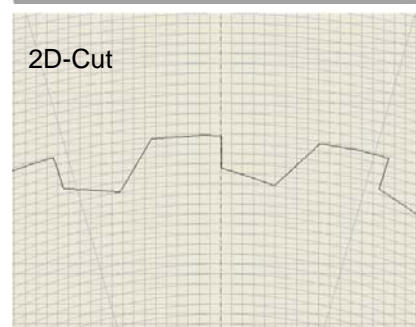
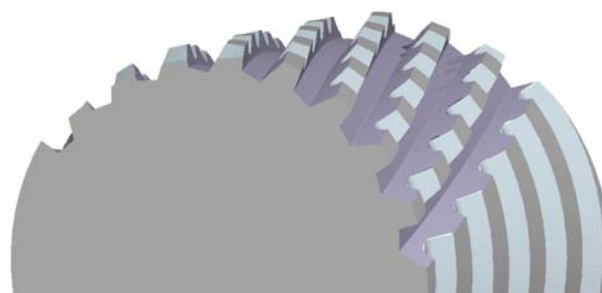


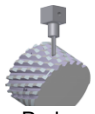
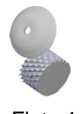

Gearhob High Spiral Ø110 Z22

A12-021

The left hand cut gear hob with high spiral angle - 30 degrees - can be ground to a perfectly straight cutting face by using a 15 degree wheel with superposing an automatically calculated curvature of 0.35 mm on the wheel angle which is applied by dressing. The resharpening cycle removes 0.2 mm of the cutting face in 3 passes.



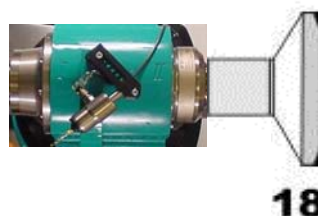
1. Cycletime for Resharpening

Tool specifications Length 120 mm, Diameter 110 mm, Z 22, Helix 29.85 deg Material HSS		
Operations	 Probe	 Flute 1
Feed [mm/Min]	2000	700
Power [kW]		2
Cutting feed [m/s]		38
Used wheels		 18
Grinding time [s]	31	1033
Total cycle time	17 Min 44	

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

18 Ø125 12V2 B76



18

3. Machine and Software Requirements

Machines: 5 axes CNC grinders : CORVUS GDS, GEMINI DMR, integrated dressing
Control: Fanuc 31i
Coolant: Synthetic Oil, pressure 6 - 7 bar
Software: Quinto 5

responsible engineer: OP, 2.3.07

www.schneeberger.ch

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TECHNOLOGY
FOR TOOLING